

Date: Friday, 7/4/2008 12:48:15 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HINGE PANEL ROLLER KIT
Job Number : 40270	
Estimate Number : 13452	
P.O. Number :	Part Number : D412698025
This Issue : 7/4/2008 S.O. No. :	Drawing Number : DSI9409 PRELIMINARY A E
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PREL A E
Previous Run :	Material :
Written By :	Due Date : 7/11/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.7.07</u>	
Comment : Est Rev:A New Issue 08.07.03 EC verified by:LL	

Additional Product :

Job Number:



Seq. # Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JUD 08.7.08



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP-DSI9409 CHG001

500/410

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3121144 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

batch: 39015

AS 08/07/07 (X)

4.0 D3121144 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bracket Assembly

39015

AS 08/07/07 (X)

5.0 D32383 Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Plate

B33515

AS 08/07/07 (X)

6.0 D323813 Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Plate

33513x3

* New Batch.

(B40298 x1)

AS 08/07/07 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE PANEL ROLLER KIT

Job Number: 40270

Part Number: D412698025

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808/7/10 @

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-034 025

Location: _____

PPP Rev: _____

Draft

AS 08/07/10 (X1)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



-mf 08-07-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

SUPPLEMENTAL TO INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-698 REV. 5
(REF. TCCA STC SH92-43, FAA STC SR01446NY & EASA STC EASA.IM.R.S.00709)

PURPOSE

THE PURPOSE OF THE D412-698-025 KIT IS TO ALLOW OPERATORS THAT HAVE PERFORMED THE BELL/AUGUSTA SERVICE INSTRUCTION TA212-138/2-22B TO THE LH/RH CABIN DOORS TO REPLACE THE EXISTING P/N 205-031-435-001 & 205-031-435-002 ROLLERS WITH DART P/N D3121-143 & D3121-144 ROLLERS (SEE FIGURE 2 FOR LOCATION). THERE IS A NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

PROCEDURE

- 1.) REMOVE HINGE PANEL DOOR PER AIRCRAFT MAINTENANCE MANUAL.
- 2.) REMOVE BELL P/N 205-031-435-001 AND 205-031-435-002 ROLLERS. RETAIN HARDWARE IF AIRWORTHY.
- 3.) INSTALL DART P/N D3121-143 & D3121-144 USING EXISTING HARDWARE AND SHIMS IF AIRWORTHY. REPLACE EXISTING BELL SHIMS IF NO LONGER AIRWORTHY WITH WITH DART P/N D3238-3/-13 AS REQUIRED (SEE FIGURE 1). TORQUE FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.
- 4.) RE-INSTALL MODIFIED DOOR ON AIRCRAFT PER AIRCRAFT MAINTENANCE MANUAL.
- 5.) CHECK SLIDING OPERATION OF DOOR. ADJUST POSITION/SHIMMING OF ALL NEW BRACKETS UNTIL DOOR OPERATION IS SMOOTH AND FREE OF DRAGGING/BINDING THROUGH FULL TRAVEL OF DOOR. RE-TORQUE ALL FASTENERS PER AIRCRAFT MAINTENANCE MANUAL.

NOTE: ENSURE VERTICAL ROLLERS ARE SITTING FLUSH TO THE DOOR TRACKS TO PREVENT ROLLER WEAR AND PREMATURE DOOR TRACK WEAR.

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 08.07.02
CERT. NO.: SH92-43
ISSUE NO.: 5

A	NEW ISSUE	AJS	08.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>AJS</u>		
CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9409	SHEET 1 OF 4
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	HINGE PANEL ROLLER KIT	NTS
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D3121-144 BRACKET ASSEMBLY

D3121-143 BRACKET ASSEMBLY

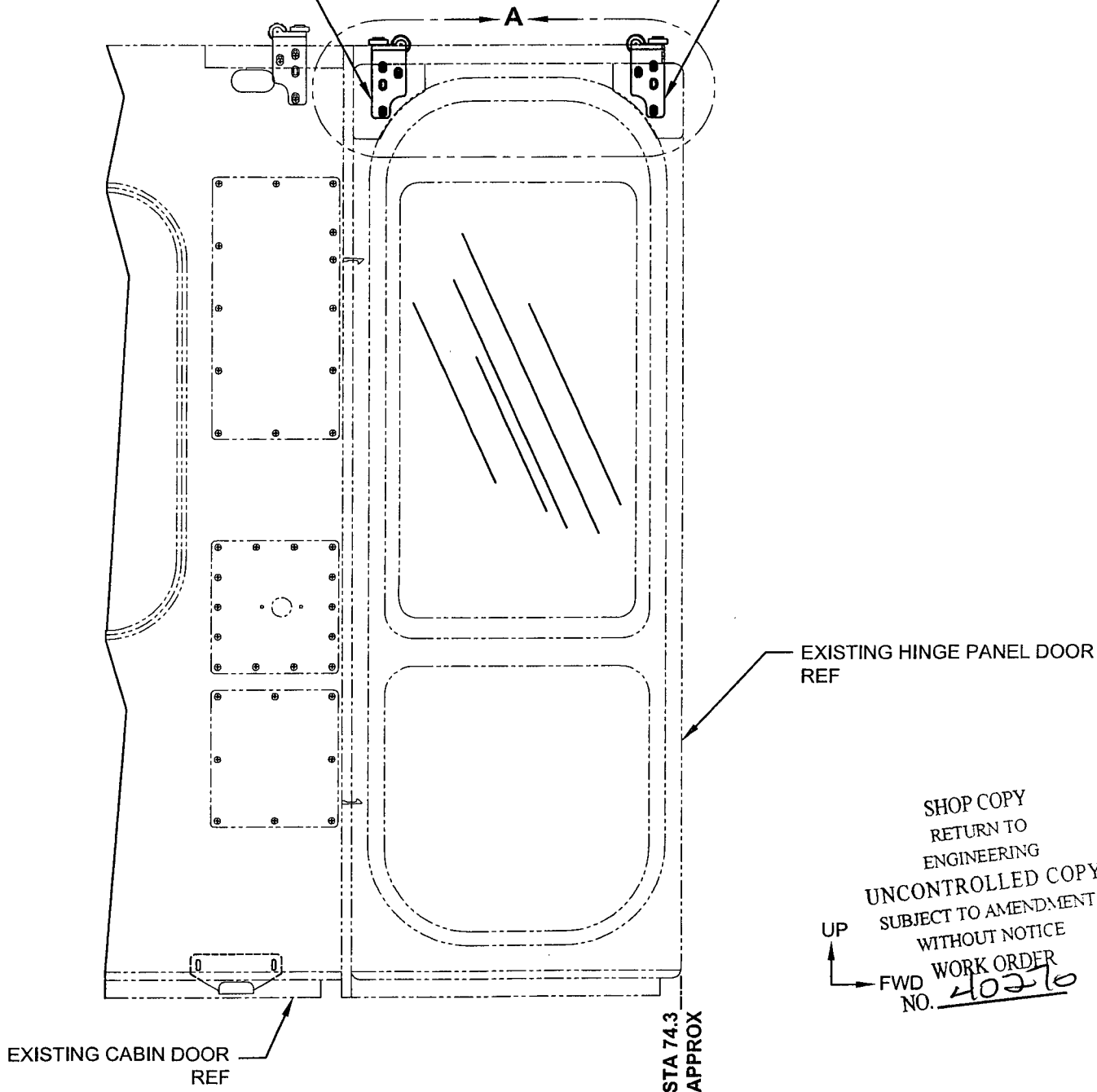


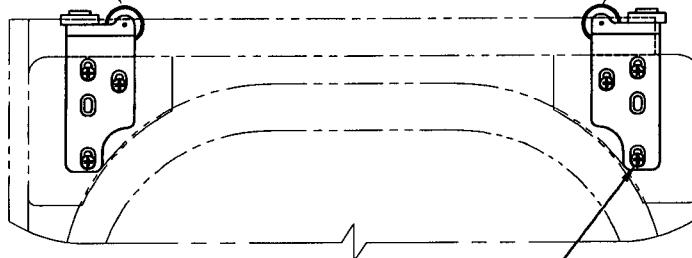
FIGURE 1. D412-698-025 HINGE PANEL DOOR ROLLER KIT
(VIEW OF L/H HINGE PANEL DOOR LOOKING OUTBOARD, R/H DOOR OPPOSITE)

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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MFG. APPR.	N/A	DSI 9409	SHEET 2 OF 4
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(1) D3121-144 BRACKET ASSEMBLY REF
 (1) D3238-3 SHIM (AS REQUIRED)
 (1) D3238-13 SHIM (AS REQUIRED)
 LOCATE FROM EXISTING
 FASTENER HOLES



(1) D3121-143 BRACKET ASSEMBLY REF
 (1) D3238-3 SHIM (AS REQUIRED)
 (1) D3238-13 SHIM (AS REQUIRED)
 LOCATE FROM EXISTING
 FASTENER HOLES

RE-USE EXISTING HARDWARE

DETAIL A VIEW ON L/H HINGE PANEL DOOR (LOOKING OUTBOARD)
(RH DOOR OPPOSITE)

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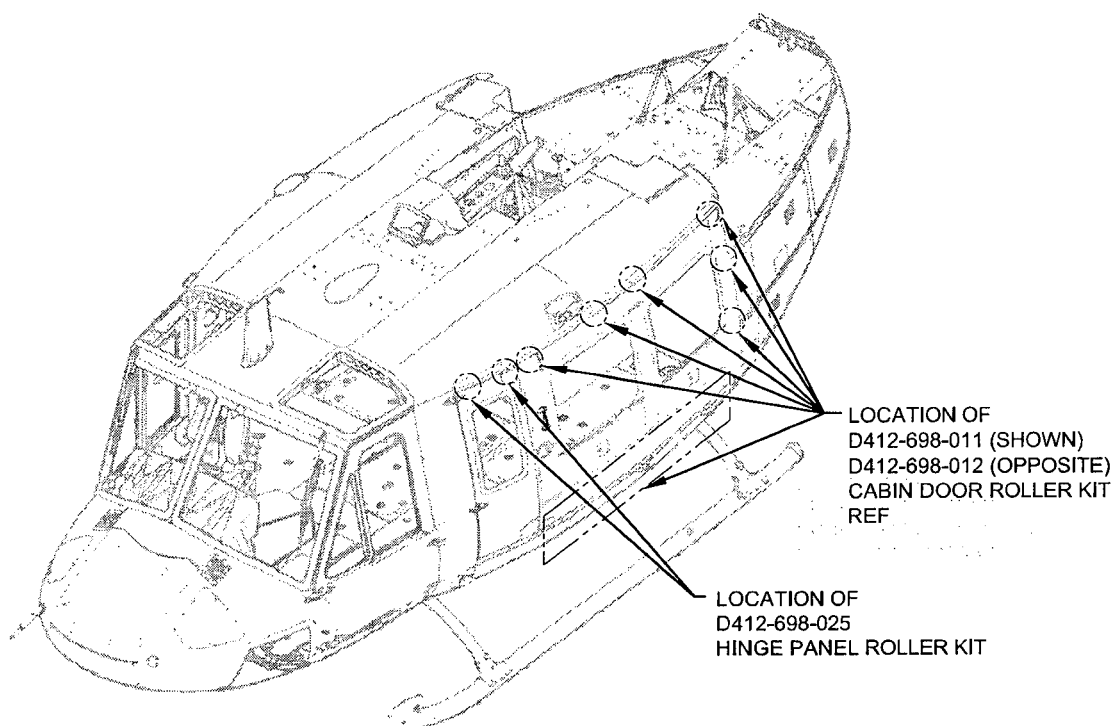


FIGURE 2. LOCATION OF D412-698-025 HINGE PANEL ROLLER KIT
(D412-698-011/-012 SHOWN FOR REFERENCE ONLY)

TABLE 1. PARTS LIST FOR D412-698-025

Qty -025	Part Number	Description
X	D412-698-025	HINGE PANEL DOOR ROLLER KIT (FITS L/H OR R/H DOOR)
1	D3121-143	BRACKET ASSEMBLY
1	D3121-144	BRACKET ASSEMBLY
2	D3238-3	SHIM
4	D3238-13	SHIM

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